

shg Oct 25/10  
**Work Order ID 62588 - 2**

Monday, October 04, 2010 3:49:28 PM

Split #2



Page 1

Item ID: D2724-042

Accept



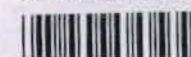
Setup Start



Revision ID:

blue

Stop



Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf

Date: 10-10-04 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Cut D2724-2 using D2622 extrusion as per Dwg D2724  
Deburr and bevel ends for welding

10-10-07

4

110

0.00



Large Fab

Large Fab

Memo

0.00

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898  
followed by Jig  
A/R AL ROD Batch: M108436  
M114877  
Grind end cap welds flush

10-10-20 4

# Work Order ID 62588

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Page 2

Item ID: D2724-042

Revision ID:

Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00

Required Date: 10/29/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 - BE 10/10/21

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

4 - 10/10/21

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> M 10/10/21

4 - 10/10/21

# Work Order ID 62588

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Page 3

Item ID: D2724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

*10.10.21*

*4*

Quality Control

160

Large Fab

0.00



Large Fab

Memo

0.00

*10.10.22*

*4*

Large Fab

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724  
A/R AL ROD Batch: *m108436*

Grind end plate flush.

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

*4* *8/10/25*

Quality Control



# Work Order ID 62588

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Page 4

Item ID: D2724-042

Accept

Revision ID:

Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00

Required Date: 10/29/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8/10/10/25



190



HandFinish

Hand Finishing

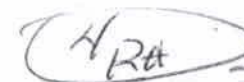
Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

10-10-25



205



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

0.00

0.00

Memo

PRIME B 115967  
PAINT DELFLEET BLUE B 115509  
CLEAR DELFLEET BLUE B 115944

ml 10 11 02 (2)

# Work Order ID 62588

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Item ID: D2724-042

Accept



Setup Start



Revision ID:

Item Name: 206L Step Assembly

Stop



Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

10 10 11 03 ②

220

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

2 10-11-4

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 10/11/04

2 0

# Work Order ID 62588

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Page 6

Item ID: D2724-042

Accept

Revision ID:

Item Name: 206L Step Assembly

Start Date: 10/5/2010 Start Qty: 4.00

Required Date: 10/29/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00

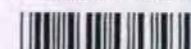


QC

Memo

0.00

Quality Control



HP 62588

10/11/09

10/11/09  
ME  
10-11-9

# Picklist Print

Monday, October 04, 2010 3:49:27 PM

Page 1

Work Order ID: 62588

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly



Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2734



Step End Plate

Manufactured

No

110

Each

67.0000

1

4



10.10.20

Location

Loc Qty

Loc Code

WA

67

60216

7

61209

60

D3458-1



Step Mounting Plate

Manufactured

No

110

Each

25.0000

2

8



10.10.20

Location

Loc Qty

Loc Code

WA

25

51239

3

53408

22

D3458-3



Step Mounting Plate

Manufactured

No

110

Each

8.0000

2

8



10.10.20

Location

Loc Qty

Loc Code

WA

8

53409

8

D2734



Step End Plate

Manufactured

No

160

Each

67.0000

1

4



10.10.20

Location

Loc Qty

Loc Code

WA

67

60216

7

61209

60

4



# Picklist Print

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Page 2

Work Order ID: 62588

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly



Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

D2622-120C

Manufactured No

100

Each

156.4200

1

4



Step Extrusion



*10-10-07*

## Location

## Loc Qty

## Loc Code

WA

156.42

55214

3.42

58544

25

61208

128

2  
2

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Shop Packet Print

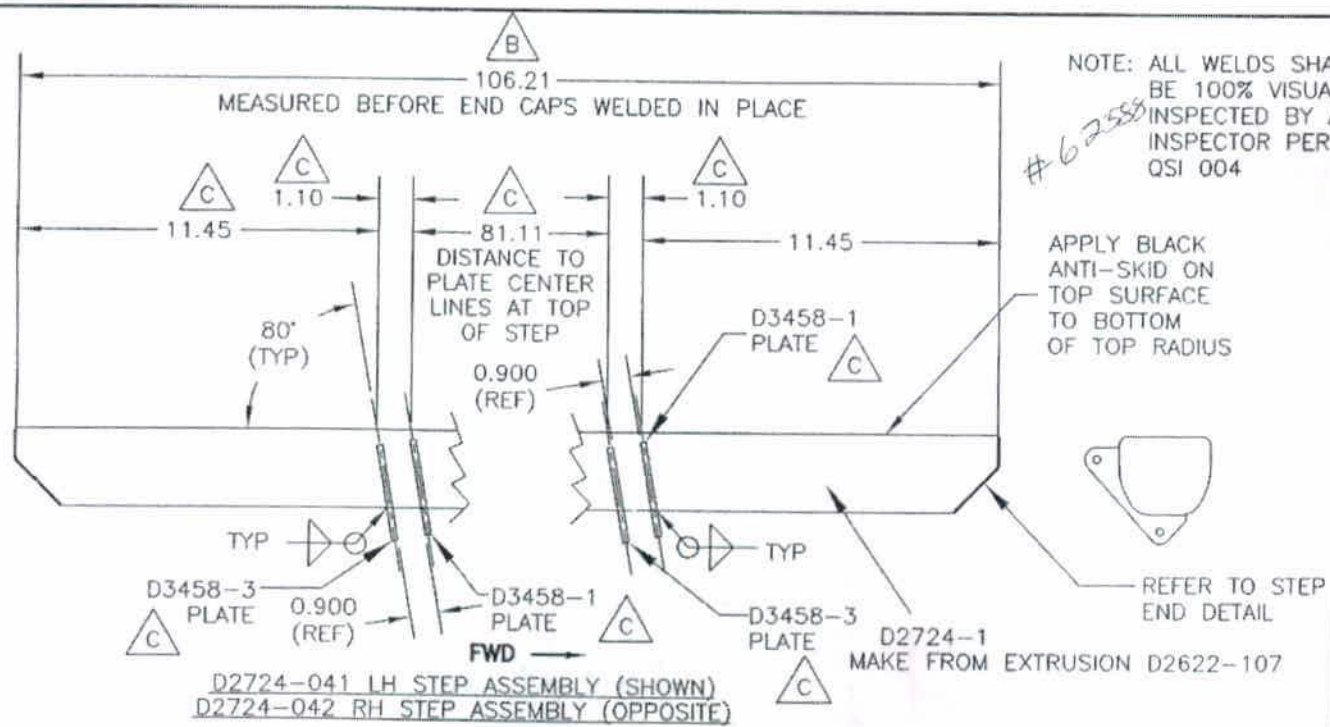
Page 2



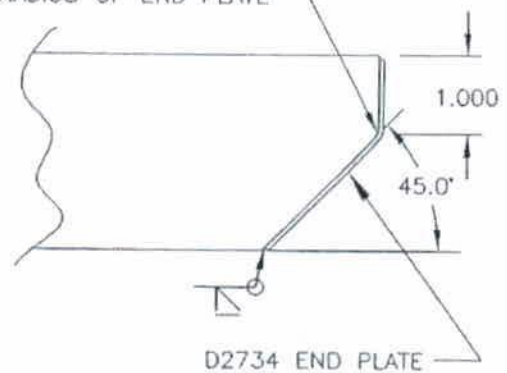
**DART**

RELEASED  
05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	05.09.19	TITLE	206L/407 STEP ASSEMBLY	REV. C
				SHEET 1 OF 1
				SCALE
				NTS
				RE-DESIGN, ADD D3458-1/-3
				UPDATED WELD DETAIL REVISED TOLERANCES
				NEW ISSUE
				97.12.04
				98.10.19
				05.09.19

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